

Work Order ID 143823

143823

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March 23, 2016 9:29:01 AM

Item ID: D3262-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Cap

Start Date: 3/30/2016 Start Qty: 12.00 *12*

Required Date: 4/8/2016 Req'd Qty: 12.00 *12*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: SH Date: 20160323 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3262	F								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr								
110	HAAS CNC VERTICAL MACHINING #1	0.01							
110									
HAAS 1	Memo	0.13							
HAAS CNC vertical machine #1	Machine as per dwg D3262								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

12 0 160324

12 0 163-27

12 0 16-327

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D3262-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 3/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130						12	10		16/03/36
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>W/A01</u>	0.00							
140						12	12	16-4-7	
Packaging	Memo	0.00							
Packaging	LOCATION : WA003								
150	QC21- Final Inspection - Work Order Release	0.00							
150						MCS		APR 08 2016	
QC	Memo	0.02							
Quality Control									

MCS APR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Picklist Print

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Work Order ID: 143823

143823

Parent Item: D3262-3

D3262-3

Parent Item Name: Cap

Start Date: 3/30/2016

Required Date: 4/8/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C05.03.10Removed P/O for liquid penetrant
inspectionKJ/JLM
Rev:D as per ECN10-571 DD 10.05.10 verified :EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased		No		100	f	25.7510	0.45	5.684211			

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

139

Location

Loc Qty

Loc Code

MAT001

25.751

112567

0.83

122521

12

m128437

0.921

m129375

12

5.5

P 160324

DART AEROSPACE LTD		Work Order:	143823
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262 Rev: F		Page 1 of 1	

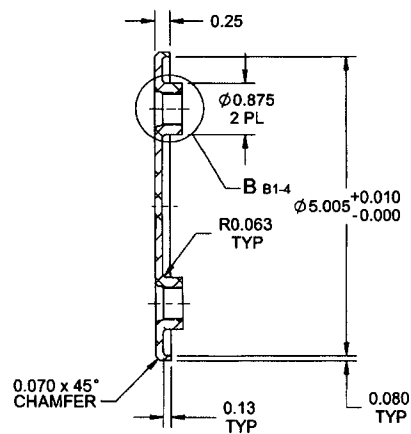
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.06 x 45°	✓		VPRN	✓
0.13	+/-0.030	0.129	✓			
R0.063	+/-0.010	0.063	✓			
0.080	+/-0.010	0.079	✓			
0.25	+/-0.030	0.251	✓			
Ø5.005	+0.010/-0.000	5.005	✓			
Ø0.875	+/-0.010	0.875	✓			
3.25	+/-0.005	3.250	✓			
Ø0.516	+0.005/-0.000	0.518	✓			
Ø5.165	+/-0.010	5.164	✓			
0.696	+0.007/-0.008	0.691	✓			
0.588	+0.005/-0.000	0.591	✓			
0.091	+0.007/-0.008	0.094	✓			
0.45	+/-0.030	0.449	✓			

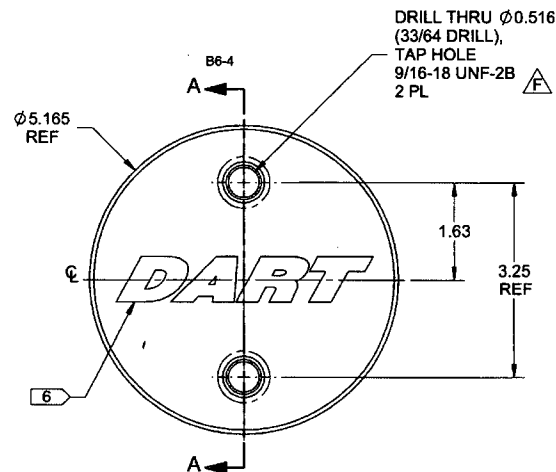
DAS

Measured by: SL	Audited by: 14 9-89	Preliminary Approval:
Date: 16-3-27	Date: 16/03/30	Date:

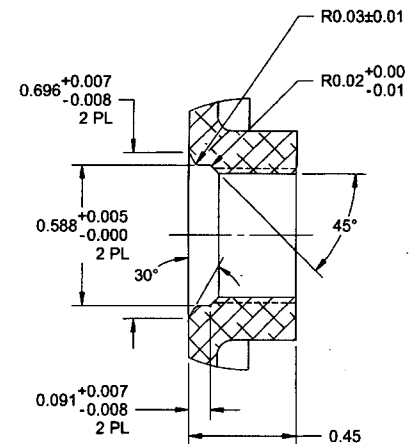
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	
E	10.08.03	Dimensions update per Dwg Rev E	KJ	
F	14.08.26	Dwg Rev updated to Rev F	KJ	



SECTION A-A C5-4



D3262-3 CAP



DETAIL B C7-4
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

20160322

SW 143823

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. F
MFG. APPR.	JLM	D3262	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FUEL PURGE CANISTER	NTS
DATE	14.06.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE
2014-07-15